

Work Order ID 63313



Page 1

Wednesday, October 27, 2010 2:58:25 PM

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

*Split
24*


Start Date: 10/27/2010 Start Qty: 50.00

Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 50.00

Customer:



Reference:

Approvals:

Process Plan:



Date: 10-10-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3537	Rev C	

100



FLOW WATER JET

0.00

10-10-29

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-10-29

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

10-10-29

QC

Memo

0.00

Quality Control

10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Brake NC

Memo

0.00

140



Large Fab

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
M15553 □1-Weld as per Dwg D3537 using Jig DT 8210 □2-Remove any
 weld that penetrated through Wearpad if necessary
4115879



SB 10/11/01

SM 10/11/08

150



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Quality Control

Memo

0.00

Solins



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Required Date: 11/11/2010 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC5- Inspect part completeness to step on W/O QC Quality Control	0.00 0.00	81014108			24	0	0	QC5-108 10/24
170 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Powdercoat Powder Coating	0.00 0.00	245	005	24	24	0	0	24 10/11/08
180 	QC3- Inspect Part Finish QC Quality Control	0.00 0.00	24	10/11/08	24	0	0	0	24 10/11/08

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



Revision ID:

Item Name: Wearpad

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Cust Item ID:

Customer:

Required Date: 11/11/2010 Req'd Qty: 50.00



Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
Description

Identify as per dwg & Stock Location:

Memo

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

24 BL 10/11-8.

190

Packaging

Packaging

0.00

200



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/11/08

MF
10-11-8.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, October 27, 2010 2:58:29 PM

Work Order ID: 63313



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 50.00

Required Qty: 50.00

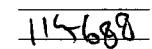
Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	189.1000	0.106	5.578947		186-10-29	

304/316 Sheet .063



Location	Loc Qty	Loc Code
MAT	189.1	
111323	0	
115688	29.1	
115953	160	



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63313
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>FB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-10-29	Date: 10/10/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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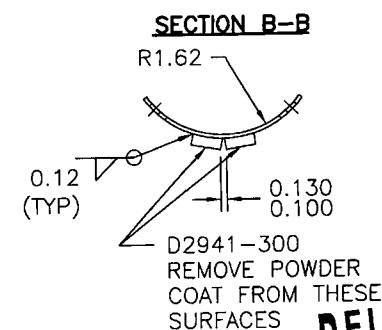
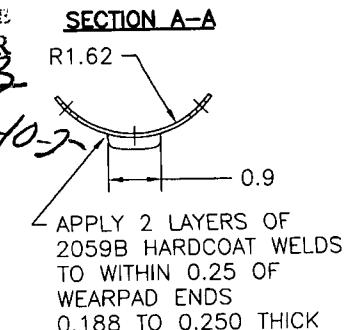
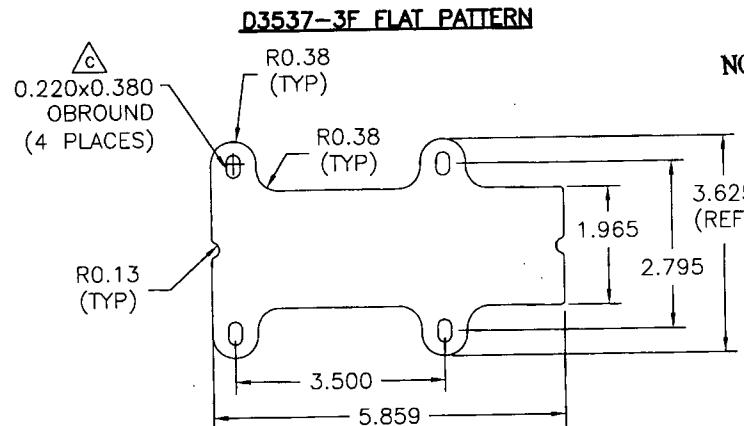
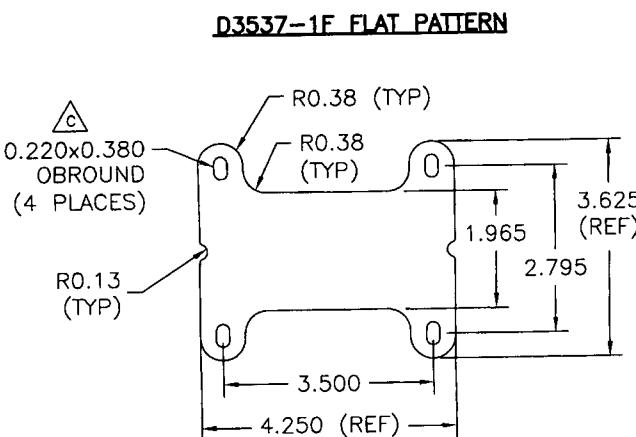
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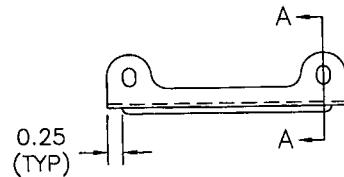
SACI COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

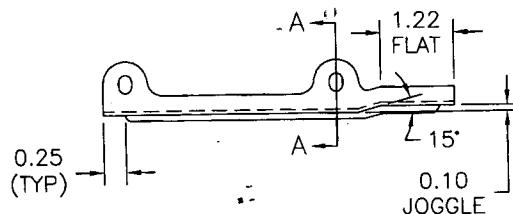
WITHOUT NOTICE
WORK ORDER
NO. 63313
PL 10-10-2



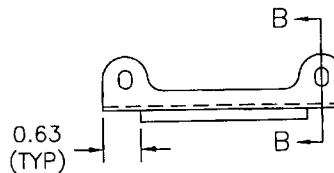
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



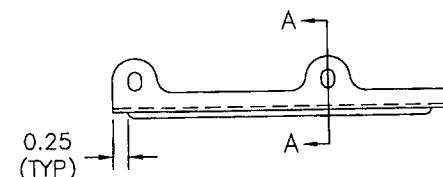
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DATE	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
07.04.13	4	TITLE WEARPAD SCALE 1:2

RELEASED
07.05.08 AM
per ELN
952

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